

- with the condition that  $(C)+(D)+(M)$  is between 0 and 50%,
- the remainder to 100% being a semi-crystalline polyamide (A).

The invention also relates to the articles obtained, such as plates, films, sheets, tubes and profiles, the articles obtained by injection moulding and in particular the films and sheets which are then bonded to skis.

The invention also relates to the above articles decorated, for example, by sublimation, and coated with a transparent protective layer consisting of the composition of the invention.

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## POLYAMIDE-BASED TRANSPARENT COMPOSITION

### FIELD OF THE INVENTION

5 The present invention relates to a polyamide-based transparent composition. The present invention also relates to the articles obtained from this composition and to processes for preparing such articles. Polyamides are polymers that are widely used for their numerous properties. Specifically, polyamides  
10 have some or all of the properties listed below: transparency, impact strength, tensile strength and/or compressive strength, high resistance to external attack, such as by cold, heat, chemical agents, UV radiation in particular, and the like. Thus, polyamide-based articles such as, for example, spectacle frames, various types of casing, motor vehicle equipment, surgical equipment, packaging, sporting and ski articles, in particular a ski topsheet, have appeared. These articles should usually carry various  
15 inscriptions, for instance the characteristics of the product sold in the case of a packaging made of polyamide. These products should also often be decorated.

25 One example of a product which needs to be decorated is a ski, in particular the topsheet. It has thus naturally been sought to decorate the polyamides according to the techniques usually used and in particular that of sublimation. This technique, known as decoration by sublimation or heat transfer, consists  
30 in coating the article to be decorated with a layer of pigments at a temperature of between 80°C and 220°C, and in heating the assembly to a given temperature. The pigments are said to be sublimable, but this technique is effective with pigments which can migrate into the structure of the polymer. In point of fact, the person  
35 skilled in the art understands this term "decoration by sublimation" without it being necessary to go into further detail here. The temperature to which the article to be decorated is brought should be high

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- enough to bring about the sublimation or heat transfer of the pigments, which may then penetrate, by diffusion, into the structure of the polymer, if this polymer is of suitable morphology. Needless to say, the
- 5 polymer should withstand the temperature used during the decoration by sublimation.

#### THE PRIOR ART AND THE TECHNICAL PROBLEM

- The polyamides of the prior art do not always
- 10 have the required properties to be decorated by sublimation. If the polyamide is crystalline or semi-crystalline, it withstands high temperatures and the often harsh conditions for carrying out decoration by sublimation which may be used with this polyamide.
- 15 However, crystalline or semi-crystalline polyamides are not transparent and their opacity makes them unsuitable for use when transparency is desired. If the polyamide is amorphous, it is thus transparent and, on account of this transparency, may be suitable in applications in
- 20 which this transparency property is desired. However, when the temperature used for the sublimation is below the glass transition temperature, the polyamide does not have a sufficiently disorganized structure and the sublimable pigments diffuse into the polyamide bulk
- 25 with difficulty. The resulting colour is pale and thus unsuitable for marketing. When the temperature used for the sublimation is higher than the glass transition temperature, the polyamide becomes unacceptably deformed and is thus unsuitable for the use for which
- 30 it is normally intended.

- Patents Fr-A-2 575 756 and FR-A-2 606 416 disclose amorphous polyamide compositions based on BACM (bis(4-aminocyclohexyl)methane), BAMCM (bis(3-methyl-4-aminocyclohexyl)methane) or other cycloaliphatic
- 35 diamines, isoterephthalic or terephthalic acid, and other polyamides. These polyamides have transparency properties and are useful for manufacturing moulded articles. The said document describes a moulding temperature which may be as high as 310°C.

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Patents JP-60-215 053 and 60-215 054 disclose and claim alloys comprising, on the one hand, a transparent polyamide and, on the other hand, a crystalline polyamide. The transparent polyamide consists of aliphatic units as essential monomer component, which are chosen from lauryllactam, 12-aminododecanoic acid and 11-aminoundecanoic acid, and cyclic units. The examples given for these transparent polyamides include, as cyclic units, a cycloaliphatic diamine, bis(4-aminocyclohexyl)methane and an aromatic diacid, isophthalic acid. The crystalline polyamide consists of Nylon-12 and/or Nylon-11, or of copolyamide having a 12 and/or 11 unit as essential monomer.

Patent FR-A-2 021 910 discloses polyamide compositions comprising from 40% to 99% by weight of an amorphous polyamide based on aromatic acids and 2,2,4-and/or 2,4,4,-trimethylhexamethylenediamine and 60% to 1% by weight of an aliphatic polyamide. The articles obtained are transparent, show good rigidity and are impact- and water-resistant. The polyamides are used for the manufacture, by moulding, of hollow articles such as bottles. The temperatures used are conventional temperatures.

Patent US-A-4 404 317 discloses polyamide compositions such as 6,I/6,T/BACM,I/BACM,T which have properties that are useful for manufacturing articles. These polyamides are obtained by blending at a temperature of between 270°C and 300°C. According to the said document, the blends have properties of resistance to solvents, heat stability and conservation of the mechanical properties under wet conditions. US-A-4 404 317 discloses blending conditions, such as the temperature, for various polyamides; in particular, it is recommended not to exceed 300°C on account of the degradation of the crystalline polyamide and also of the amorphous polyamide. It is also known that crystalline polyamides (including PA-12 or PA-6,12) have a degradation temperature of about 270°C, both for

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injection-moulding and for extrusion. This temperature may be raised for very brief periods or in the presence of a stabilizer to a temperature of about 300°C.

Patent EP 0 628 602 discloses blends of  
5 amorphous polyamide and of semi-crystalline polyamide. The examples were carried out on a Werner 30 twin-screw extruder equipped with a blender section, at a material temperature of 330 to 340°C, starting firstly with a semi-crystalline polyamide PA-11 with an inherent  
10 viscosity of 1.38 dl/g and secondly with an amorphous semi-aromatic polyamide PA-12/BMACM, T/BMACM, I. The latter polyamide is synthesized by melt-polycondensation starting with bis(3-methyl-4-aminocyclohexyl)methane (BMACM), lauryllactam (L12) and  
15 isoterephthalic and terephthalic acid (IA and TA) in a 1/1/0.3/0.7 molar ratio. This amorphous polyamide has a glass transition temperature of 170°C and an inherent viscosity of 1.05 dl/g. The blends leaving the Werner extruder dye are cooled in the form of rods in a tank  
20 filled with cold water, cut into granules and heated at 80°C under vacuum for 12 hours so as to remove the moisture.

The prior art has disclosed either semi-crystalline polyamides or amorphous polyamides, or  
25 alternatively mixtures thereof. Semi-crystalline polyamides and amorphous polyamides are unsuitable for articles which need to be decorated by sublimation. As regards blends of semi-crystalline polyamides and of amorphous polyamide, the amorphous polyamide always  
30 contains aromatic units, generally isophthalic acid or terephthalic acid, which necessitates the use of high temperatures to blend them, resulting in a risk of degradation and a cost which is proportionately higher the higher the temperature. Furthermore, these  
35 polyamides containing aromatic units have a high modulus of flexure and are thus rigid and difficult to use, for example for applying them to a ski during the manufacture of the ski.

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A polyamide-based transparent composition has now been found, which consists essentially of a blend of aliphatic polyamide and of a polyamide containing cycloaliphatic units but no aromatic units.

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The present invention relates to a transparent composition comprising, by weight, the total being 100%:

- 10 • 5 to 40% of an amorphous polyamide (B) which results essentially from the condensation:
- either of at least one diamine chosen from cycloaliphatic diamines and aliphatic diamines and of at least one diacid chosen from cycloaliphatic diacids and aliphatic diacids, at least one of these diamine or diacid units being cycloaliphatic,
  - or of a cycloaliphatic  $\alpha,\omega$ -aminocarboxylic acid,
  - 20 ➤ or of a combination of these two possibilities, and
  - optionally of at least one monomer chosen from  $\alpha,\omega$ -aminocarboxylic acids or the possible corresponding lactams, aliphatic diacids and aliphatic diamines,
  - 25 • 0 to 40% of a supple polyamide (C) chosen from copolymers containing polyamide blocks and polyether blocks and copolyamides,
  - 0 to 20% of a compatabilizer (D) for (A) and (B),
  - 30 • 0 to 40% of a supple modifier (M),
  - with the condition that (C)+(D)+(M) is between 0 and 50%,
  - the remainder to 100% being a semi-crystalline polyamide (A).

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The term "transparent" corresponds to a coefficient of light transmission of greater than or equal to 50%, measured at 560 nm and for a thickness of 2 mm. It is preferably  $\geq 80\%$ .

The term "polyamide" used in the present description also covers copolyamides, which may contain third monomers in a proportion which does not affect the essential qualities of the polyamides.

- 5       The term "semi-crystalline" covers (co)polyamides which have both a glass transition temperature  $T_g$  and a melting point m.p.

10       The term "amorphous" covers polyamides which change to the liquid or molten state, and thus which may be used, above their  $T_g$ . In principle, these polymers do not have an m.p. in DSC. However, they may have one, but, if they do, its intensity is negligible and does not affect the essentially amorphous nature of the polymer.

- 15       The definitions according to the present invention are in accordance with those commonly accepted in the art. Reference will be made advantageously to the publication "ENPLAS, Booklet on Engineering Plastics", section 2.1, pp. 12-13, Ed. 1991  
20       published by "The Japan Engineering Association".

      The composition of the invention has many advantages:

- It is semi-crystalline like the polyamide (A), i.e. it can be decorated by sublimation. The  
25       crystalline structures are small enough for the composition to be transparent.

- It is not too rigid like the semi-aromatic polyamides of the prior art. Its modulus of flexure may be between 1 400 and 600 MPa, the measurement being  
30       made on a sample conditioned for 15 days at 23°C and 50% RH (relative humidity). Specifically, PA 11 has a modulus of flexure of 1 000 MPa, which is considered as average by comparison with a rigid polyamide with a modulus of flexure of 2 000 MPa and a supple polyamide  
35       with a modulus of flexure of 500 MPa.

      It is ductile, has good impact strength and crack resistance, and also good abrasion resistance. An article such as a sheet will be suitable for the various shaping operations (cold moulding, drawing)

which may be required to obtain a finished product such as a ski.

Furthermore, it has low moisture sensitivity, essentially since, for (A), the monomers used contain at least 9 carbon atoms, for example: PA11, PA12, PA10.12, coPA9/10.2. By virtue of the semi-crystalline nature of (A), it has good chemical resistance, good cracking stress resistance and good ageing resistance.

It is easy to manufacture since the temperature at which there is formation of a transparent material is low enough to be very close and even identical to, or even lower than, the usual compounding temperature (melt blending in an extruder or a mixer) of (A). Typically, this temperature is about 270°C. This temperature is proportionately lower the larger the amount of (D). In the prior art, the aliphatic polyamide and the semi-aromatic polyamide need to be compounded at about 310°C or 340°C. The advantage of this lower temperature is that this new material can be produced under the usual compounding conditions, there is no degradation, the composition does not yellow, it has few problems or gel temperatures, if any, and the composition is easier to recycle (it may undergo a new use more easily).

It is very easily used, typically by extrusion. The properties of the molten material are adequate (sufficient viscosity) and stable (no fluctuation during the production of the article) and there are no fumes or deposits, unlike certain transparent polyamide compositions of the prior art.

The invention also relates to articles consisting of the composition of the invention, such as plates, films, sheets, tubes and profiles, to the articles obtained by injection-moulding and in particular to films and sheets which are then bonded to skis.

The invention also relates to the above articles decorated, for example, by sublimation, and

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coated with a transparent protective layer consisting of the composition of the invention.

DETAILED DESCRIPTION OF THE INVENTION

5           As regards the semi-crystalline polyamide (A),  
mention may be made (i) of aliphatic polyamides which  
are the products of condensation of an aliphatic  $\alpha$ ,  
 $\omega$ -aminocarboxylic acid, of a lactam or the products of  
condensation of an aliphatic diamine and of an  
10 aliphatic diacid and (ii) other polyamides provided  
that they are semi-crystalline. Among these other semi-  
crystalline polyamides, the ones that are preferred are  
those which have crystalline structures that are small  
enough to be close to transparency; by way of example,  
15 mention may be made of the PA PACM-12 in which PACM  
denotes para-aminodicyclohexylmethane and 12 denotes  
the C12 diacid.

By way of example of aliphatic  $\alpha$ ,  
 $\omega$ -aminocarboxylic acids, mention may be made of amino-  
20 caproic acid, 7-aminoheptanoic acid, 11-aminoundecanoic  
acid and 12-aminododecanoic acid. As examples of  
lactams, mention may be made of caprolactam,  
oenantholactam and lauryllactam. As examples of  
aliphatic diamines, mention may be made of  
25 hexamethylenediamine, dodecamethylenediamine and  
trimethylhexamethylenediamine. As examples of aliphatic  
diacids, mention may be made of adipic acid, azelaic  
acid, suberic acid, sebacic acid and  
dodecanedicarboxylic acid.

30           Among the aliphatic polyamides, mention may be  
made, by way of example and in a non-limiting manner,  
of the following polyamides: polycaprolactam (PA-6);  
polyundecanamide (PA-11); polylauryllactam (PA-12);  
polybutyleneadipamide (PA-4,6); polyhexamethylene-  
35 adipamide (PA-6,6); polyhexamethyleneazelamide (PA-  
6,9); polyhexamethylenesebacamide (PA-6,10); polyhexa-  
methylenedodecanamide (PA-6,12); polydecamethylene-  
dodecanamide (PA-10,12); polydecamethylenesebacanamide

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(PA-10,10) and polydodecamethylenedodecanamide (PA-12,12).

Advantageously, (A) is derived from the condensation of a lactam containing at least 9 carbon atoms, of an  $\alpha$ ,  $\omega$ -aminocarboxylic acid containing at least 9 carbon atoms or of a diamine and a diacid such that the diamine or diacid contain at least 9 carbon atoms. Advantageously, (A) is PA-11 or PA-12 and preferably PA-12. It would not constitute a departure from the context of the invention if (A) was a blend of aliphatic polyamides.

According to another advantageous form, (A) is an equilibrated polyamide. The names of the polyamides are recalled below according to their end groups.

According to their process of manufacture and/or the chain limiter used, the polyamides may have excesses of acid or amine end groups or may even have a proportion of alkyl or other end groups, for example aryl or any other function, deriving from the structure of the limiter chosen. The excess of acid end groups derives from a diacid chain limiter. The excess of amine end groups derives from a diamine chain limiter. A primary amine chain limiter leads to a polyamide chain having an alkyl end and an amine end.

The name diamine polyamide,  $\text{PA diNH}_2$ , refers to a polyamide which satisfies the following criteria:

- \* it has a certain amount of chains ending on both sides with an amine group ( $\text{NH}_2$ )
- \* the amount of chains ending on both sides with an amine group ( $\text{NH}_2$ ) is greater than that of diacid chains (if any)
- \* the concentration of amine groups is greater overall than the concentration of acid groups
- \* a  $\text{PA diNH}_2$  is obtained by adding a diamine as chain limiter or, in the case of polyamides based on diamine and on diacid such as, for example, PA6-6, by adding more diamine comonomer than diacid comonomer.

These polyamides are thus also known for simplicity as PA diamine or  $\text{PA diNH}_2$ .

A polyamide is referred to as a diacid for the opposite reasons.

A polyamide is equilibrated if

\* a limiter or an excess of one of the  
5 comonomers has not been added

\* if the concentration of amine and of acid is essentially equivalent.

To determine the nature of the ends of a polyamide and the percentage of chains having these  
10 endings, it is possible to use the known methods for determining the molar masses, such as, for example, SEC (steric exclusion chromatography) and the methods for assaying amine and acid functions. In the present application, the term SEC denotes the measurement of  
15 the molecular masses of polymers by steric exclusion chromatography, this technique and more particularly its application to polyamides and polyamide block polyethers being disclosed in "Journal of Liquid Chromatography, 11(16), 3305-3319 (1988)". As regards  
20 the determination of the end groups, for example for PA-6, the sample is dissolved in a solution of phenol in methanol and the amines are titrated with a solution of para-toluenesulphonic acid in methanol. For the acid end groups, again for PA-6, the sample is dissolved in  
25 benzyl alcohol and the acid functions are titrated with a solution of potassium hydroxide in benzyl alcohol.

As regards the amorphous polyamide containing a cycloaliphatic unit (B), the cycloaliphatic diamines may be the isomers of bis(4-aminocyclohexyl)methane  
30 (BACM), bis(3-methyl-4-aminocyclohexyl)methane (BMACM) and 2,2-bis(3-methyl-4-aminocyclohexyl)propane (BMACP) and para-aminodicyclohexylmethane (PACM). The other diamines commonly used may be isophoronediamine (IPDA) and 2,6-bis(aminomethyl)norbornane (BAMN). The  
35 aliphatic diacids have been described above. By way of example, mention may be made of PA-IPDA, 12 resulting from the condensation of isophoronediamine with dodecanedicarboxylic acid. The amorphous polyamide (B)

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may optionally contain at least one monomer or comonomer chosen from:

- $\alpha$ ,  $\omega$ -aminocarboxylic acids,
- aliphatic diacids,
- aliphatic diamines;

these products have been described above. As examples of (B), mention may be made of PA-IPDA,10, coPA-IPDA,10/12 and PA-IPDA,12. It would not constitute a departure from the context of the invention if (B) was a blend of several amorphous polyamides.

As regards the supple polyamide (C) and first the copolymers containing polyamide blocks and polyether blocks, these result from the copolycondensation of polyamide blocks containing reactive ends with polyether blocks containing reactive ends, such as, inter alia:

- 1) Polyamide blocks containing diamine chain ends with polyoxyalkylene blocks containing carboxylic chain ends.
- 2) Polyamide blocks containing dicarboxylic chain ends with polyoxyalkylene blocks containing diamine chain ends obtained by cyanoethylation and hydrogenation of aliphatic dihydroxylated alpha-omega polyoxyalkylenes known as polyether diols.
- 3) Polyamide blocks containing dicarboxylic chain ends with polyether diols, the products obtained in this particular case being polyetheresteramides. The copolymers (C) are advantageously of this type.

The polyamide blocks containing dicarboxylic chain ends are derived, for example, from the condensation of  $\alpha$ ,  $\omega$ -aminocarboxylic acids, lactams or dicarboxylic acids and diamines in the presence of a chain-limiting dicarboxylic acid.

The number-average molar mass  $\overline{M}_n$  of the polyamide blocks is between 300 and 15 000 and preferably between 600 and 5 000. The mass  $\overline{M}_n$  of the

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polyether blocks is between 100 and 6 000 and preferably between 200 and 3 000.

The polymers containing polyamide blocks and polyether blocks may also comprise randomly distributed units. These polymers may be prepared by the simultaneous reaction of the polyether and the polyamide-block precursors.

For example, polyetherdiol, a lactam (or an  $\alpha$ ,  $\omega$ -amino acid) and a chain-limiting diacid may be reacted in the presence of a small amount of water. A polymer is obtained essentially containing polyether blocks, polyamide blocks of very variable length, and also the various reagents which have reacted randomly and which are distributed randomly in the polymer chain.

Whether these polymers containing polyamide blocks and polyether blocks are derived from the copolycondensation of polyamide and polyether blocks prepared beforehand or from a one-pot reaction, they have, for example, Shore D hardnesses which may be between 20 and 75 and advantageously between 30 and 70 and an intrinsic viscosity of between 0.8 and 2.5 measured in meta-cresol at 250°C for an initial concentration of 0.8 g/100 ml. The MFIs may be between 5 and 50 (235°C for a 1 kg load).

The polyetherdiol blocks are either used without modification and are copolycondensed with polyamide blocks containing carboxylic ends, or they are aminated in order to be converted into polyetherdiamines and condensed with polyamide blocks containing carboxylic ends. They may also be blended with polyamide precursors and a chain limiter to make polymers containing polyamide blocks and polyether blocks with randomly distributed units.

Polymers containing polyamide blocks and polyether blocks are disclosed in patents US 4 331 786, US 4 115 475, US 4 195 015, US 4 839 441, US 4 864 014, US 4 230 838 and US 4 332 920.

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Three types of copolymer containing polyamide blocks and polyether blocks may be distinguished. According to a first type, the polyamide blocks containing dicarboxylic chain ends are derived, for example, from the condensation of  $\alpha$ ,  $\omega$ -aminocarboxylic acids, of lactams or of dicarboxylic acids and diamines in the presence of a chain-limiting dicarboxylic acid. As an example of an  $\alpha$ ,  $\omega$ -aminocarboxylic acid, mention may be made of aminoundecanoic acid, as examples of lactams, mention may be made of caprolactam and lauryllactam, as examples of dicarboxylic acids, mention may be made of adipic acid, decanedioic acid and dodecanedioic acid, and as an example of a diamine, mention may be made of hexamethylenediamine. Advantageously, the polyamide blocks are made of polyamide 12 or of polyamide 6.

According to a second type, the polyamide blocks result from the condensation of one or more  $\alpha$ ,  $\omega$ -aminocarboxylic acids and/or of one or more lactams containing from 6 to 12 carbon atoms in the presence of a dicarboxylic acid containing from 4 to 12 carbon atoms, and are of low mass, i.e. they have an  $M_n$  of from 400 to 1 000. As examples of  $\alpha$ ,  $\omega$ -aminocarboxylic acids, mention may be made of aminoundecanoic acid and aminododecanoic acid. As examples of dicarboxylic acids, mention may be made of adipic acid, sebacic acid, isophthalic acid, butanedioic acid, 1,4-cyclohexyldicarboxylic acid, terephthalic acid, the sodium or lithium salt of sulphisophthalic acid, dimerized fatty acids (these dimerized fatty acids have a dimer content of at least 98% and are preferably hydrogenated) and dodecanedioic acid  $\text{HOOC}-(\text{CH}_2)_{10}-\text{COOH}$ . Examples of lactams which may be mentioned are caprolactam and lauryllactam. Polyamide blocks obtained by condensation of lauryllactam in the presence of adipic acid or dodecanedioic acid and with an  $M_n$  of 750 have a melting point of 127-130°C.

According to a third type, the polyamide blocks result from the condensation of at least one  $\alpha$ ,

ω-aminocarboxylic acid (or a lactam), at least one diamine and at least one dicarboxylic acid. The α, ω-aminocarboxylic acid, the lactam and the dicarboxylic acid may be chosen from those mentioned above.

5 The diamine may be an aliphatic diamine containing from 6 to 12 atoms and may be aryllic and/or saturated cyclic. Examples which may be mentioned are hexamethylenediamine, piperazine, 1-aminoethylpiperazine, bisamino-propylpiperazine, tetramethylenediamine, octamethylene-

10 diamine, decamethylenediamine, dodecamethylenediamine, 1,5-diaminohexane, 2,2,4-trimethyl-1,6-diaminohexane, diamine polyols, isophoronediamine (IPD), methylpenta-methylenediamine (MPDM), bis(aminocyclohexyl)methane (BACM) and bis(3-methyl-4-aminocyclohexyl)methane

15 (BMACM).

In the second and third types, the various constituents of the polyamide block and their proportion are chosen in order to obtain a melting point of less than 150°C and advantageously between

20 90°C and 135°C.

Copolyamides with a low melting point are disclosed in patents US 4 483 975, DE 3 730 504 and US 5 459 230, and the same proportions of the constituents are adopted for the polyamide blocks.

25 The polyether blocks may represent 5% to 85% by weight of the copolymer containing polyamide and polyether blocks. The polyether blocks may contain units other than ethylene oxide units, such as, for example, propylene oxide or polytetrahydrofuran (which

30 leads to polytetramethylene glycol sequences). It is also possible to use simultaneously PEG blocks, i.e. those consisting of ethylene oxide units, PPG blocks, i.e. those consisting of propylene oxide units, and PTMG blocks, i.e. those consisting of tetramethylene

35 glycol units, also known as polytetrahydrofuran. PPG or PTMG blocks are advantageously used. The amount of polyether blocks in these copolymers containing polyamide and polyether blocks is advantageously from

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10% to 50% by weight of the copolymer and preferably from 35% to 50%.

The copolymers containing polyamide blocks and polyether blocks may be prepared by any means for  
5 attaching the polyamide blocks and the polyether blocks. In practice, two processes are essentially used, one being a 2-step process, the other a one-step process.

The 2-step process consists firstly in  
10 preparing polyamide blocks containing carboxylic ends by condensation of the polyamide precursors in the presence of a chain-limiting dicarboxylic acid and then, in a second step, in adding the polyether and a catalyst.

15 Once the polyamide containing carboxylic acid ends has been prepared, the polyether and a catalyst are then added. The polyether may be added in one or more portions, as may the catalyst.

The catalyst is defined as being any product  
20 which facilitates the bonding of the polyamide blocks and the polyether blocks by esterification. The catalyst is advantageously a derivative of a metal (M) chosen from the group formed by titanium, zirconium and hafnium.

25 This process and these catalysts are disclosed in patents US 4 332 920, US 4 230 838, US 4 331 786 US 4 252 920 JP 07145368A, JP 06287547A and EP 613919.

As regards the one-step process, all the reagents used in the two-step process, i.e. the  
30 polyamide precursors, the chain-limiting dicarboxylic acid, the polyether and the catalyst, are blended. These are the same reagents and the same catalyst as in the two-step process disclosed above. If the polyamide precursors are only lactams, it is advantageous to add  
35 a small amount of water.

The copolymer essentially has the same polyether blocks and the same polyamide blocks, but also a small portion of different reagents which have

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reacted randomly and which are distributed randomly in the polymer chain.

- Advantageously, (C) will be chosen such that it makes it possible "as a bonus" to use a smaller amount of (B) to obtain a transparent composition.

As regards the supple polyamide (C) consisting of copolyamide, this results either from the condensation of at least one  $\alpha$ ,  $\omega$ -aminocarboxylic acid (or a lactam), at least one diamine and at least one dicarboxylic acid, or from the condensation of at least two  $\alpha$ ,  $\omega$ -aminocarboxylic acids (or their possible corresponding lactams or of one lactam and of the other in  $\alpha$ ,  $\omega$ -aminocarboxylic acid form). These constituents have already been defined above.

- As examples of copolyamides, mention may be made of copolymers of caprolactam and of lauryllactam (PA 6/12), copolymers of caprolactam, of adipic acid and of hexamethylenediamine (PA 6/6-6), copolymers of caprolactam, of lauryllactam, of adipic acid and of hexamethylenediamine (PA 6/12/6-6), copolymers of caprolactam, of lauryllactam, of 11-aminoundecanoic acid, of azelaic acid and of hexamethylenediamine (PA 6/6-9/11/12), copolymers of caprolactam, of lauryllactam, of 11-aminoundecanoic acid, of adipic acid and of hexamethylenediamine (PA 6/6-6/11/12), copolymers of lauryllactam, of azelaic acid and of hexamethylenediamine (PA 6-9/12). The preferred copolyamides are copolyamides with a pronounced copolymeric nature, i.e. with essentially equivalent proportions of the various comonomers, which leads to properties that are the furthest removed for the corresponding polyamide homopolymers. It would not constitute a departure from the context of the invention if (C) was a blend of several copolymers containing polyamide blocks and polyether blocks or of several copolyamides or any combination of these possibilities.

As regards the compatibilizer (D) of (A) and (B), this is any product which reduces the temperature

required to make the blend of (A) and (B) transparent. It is advantageously a polyamide. For example, if (A) is PA-12, then (D) is PA-11. Preferably, it is a catalysed aliphatic polyamide.

5 As regards the catalysed polyamide (D), this is a polyamide as described above for (A), but containing a polycondensation catalyst such as a mineral or organic acid, for example phosphoric acid. The catalyst may be added to the polyamide (D) after it has been  
10 prepared, by any process or, quite simply, and preferably, it may be the rest of the catalyst used for its preparation. The term "catalysed polyamide" means that the chemistry continues beyond the steps for synthesis of the base resin and thus during the  
15 subsequent steps of the preparation of the compositions of the invention. Polymerization and/or depolymerization reactions may take place very substantially during the blending of the polyamides (A) and (B) and (D) to prepare the compositions of the  
20 present invention. Typically, the Applicant believes (without being bound by this explanation) that the chains continue to polymerize (chain extension) and to be branched (for example bridging by means of phosphoric acid). Furthermore, this may be considered  
25 as a tendency towards re-equilibrating the polymerization equilibrium, and thus a kind of homogenization. However, it is recommended to dry the polyamides thoroughly (and advantageously to control the moisture levels carefully) in order to avoid  
30 depolymerizations. The amount of catalysts may be between 5 ppm and 15 000 ppm of phosphoric acid relative to the resin (D). For other catalysts, for example boric acid, the contents will be different and may be chosen appropriately according to the usual  
35 techniques for the polycondensation of polyamides.

As regards the supple modifier (M), mention may be made, for example, of functionalized polyolefins, grafted aliphatic polyesters, optionally grafted copolymers containing polyether blocks and polyamide

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blocks, and copolymers of ethylene and of an alkyl (meth)acrylate and/or of a saturated vinylcarboxylic acid ester. The copolymers containing polyether blocks and polyamide blocks may be chosen from those mentioned above for (C), and supple copolymers are instead chosen, i.e. copolymers with a modulus of flexure of less than 200 MPa.

The modifier may also be a polyolefin chain with polyamide grafts or polyamide oligomers; thus, it has affinities with the polyolefins and the polyamides.

The supple modifier may also be a block copolymer containing at least one block which is compatible with (A) and at least one block which is compatible with (B).

The functionalized polyolefin is a polymer comprising  $\alpha$ -olefin units and epoxy or carboxylic acid or carboxylic anhydride units.

Examples which may be mentioned are polyolefins or SBS, SIS, SEBS, EPR (also known as EPM) or EPDM block polymers grafted with unsaturated epoxides such as glycidyl (meth)acrylate or with carboxylic acids such as (meth)acrylic acid or with unsaturated carboxylic anhydrides such as maleic anhydride. EPR denotes ethylene-polypropylene elastomers and EPDM denotes ethylene-polypropylene-diene elastomers.

The term "polyolefin" means a polymer comprising olefin units such as, for example, ethylene, propylene, 1-butene or any other alpha-olefin units. Examples which may be mentioned are:

- polyethylenes such as LDPE, HDPE, LLDPE or VLDPE, polypropylene, ethylene/propylene copolymers or alternatively metallocene PEs;

- copolymers of ethylene with at least one product chosen from unsaturated carboxylic acid esters or salts, or saturated vinylcarboxylic acid esters.

Advantageously, the polyolefin is chosen from LLDPE, VLDPE, polypropylene, ethylene/vinyl acetate copolymers and ethylene/alkyl (meth)acrylate copolymers. The density may advantageously be between

0.86 and 0.965 and the melt flow index (MFI) may be between 0.3 and 40.

Examples of supple modifiers which may also be mentioned are:

5       - copolymers of ethylene, of an unsaturated epoxide and optionally of an unsaturated carboxylic acid salt or ester or a saturated vinylcarboxylic acid ester. These are, for example, ethylene/vinyl acetate/glycidyl (meth)acrylate copolymers or  
10   ethylene/alkyl (meth)acrylate/glycidyl (meth)acrylate copolymers;

          - copolymers of ethylene, of an unsaturated carboxylic anhydride and/or of an unsaturated carboxylic acid which may be partially neutralized with  
15   a metal (Zn) or an alkali metal (Li) and optionally of an unsaturated carboxylic acid ester or a saturated vinylcarboxylic acid ester. These are, for example, ethylene/vinyl acetate/maleic anhydride copolymers or ethylene/alkyl (meth)acrylate/maleic anhydride  
20   copolymers or alternatively ethylene/Zn or Li (meth)acrylate/maleic anhydride copolymers;

          - polyethylene, polypropylene, ethylene/propylene copolymers grafted or copolymerized with an unsaturated carboxylic anhydride and then condensed  
25   with a monoamino polyamide (or a polyamide oligomer). These products are disclosed in EP 342 066.

Advantageously, the functionalized polyolefin is chosen from ethylene/alkyl (meth)acrylate/maleic anhydride copolymers, ethylene/vinyl acetate/maleic  
30   anhydride copolymers, ethylene/propylene copolymers predominantly containing propylene grafted with maleic anhydride and then condensed with monoamino polyamide 6 or monoamino oligomers of caprolactam.

Preferably, it is an ethylene/alkyl  
35   (meth)acrylate/maleic anhydride copolymer comprising up to 40% by weight of alkyl (meth)acrylate and up to 10% by weight of maleic anhydride. The alkyl (meth)acrylate may be chosen from methyl acrylate, ethyl acrylate, n-butyl acrylate, isobutyl acrylate, 2-ethylhexyl

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acrylate, cyclohexyl acrylate, methyl methacrylate and ethyl methacrylate.

5 Grafted aliphatic polyesters which may be mentioned are polycaprolactone grafted with maleic anhydride, with glycidyl methacrylate, with vinyl esters or with styrene. These products are disclosed in application EP 711 791.

10 It is recommended to select a supple modifier which does not reduce the transparency of the composition. The advantage of the compositions (A) + (B), (A) + (B) + (C) and (A) + (B) + (C) + (D) mentioned above is that they have a resulting refractive index which is close for most of the modifiers (M) mentioned. It is thus possible to add a  
15 modifier (M) of the same (or very similar) refractive index. This was not the case with the transparent polyamide compositions cited in the prior art, since their refractive indices are typically higher than the refractive index of the most common modifiers (M).

20 In general, the modifier (M) is useful for further softening or for imparting a particular property (hence its name "modifier"), without, however, losing the advantageous properties of transparency, of manufacture at low temperature and of ability to  
25 sublimate. Among these additional properties which the modifier may be provided, mention is made of: impact modifier for improving the impact strength, modifier bearing reactive functions to improve the adhesion of the material to substrates, modifier to give a matt  
30 appearance, modifier to give a silky or slippery feel, modifier to make the material more viscous in order to use it in blow-moulding.

It is advantageous to blend the modifiers in order to combine their effects.

35 Advantageous compositions are those in which the proportions of the constituents are as follows (the total being 100%) and are described in Table 1 below:

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Table 1

| A                  | B        | C+D+M   | C       | D       | M       |
|--------------------|----------|---------|---------|---------|---------|
| difference to 100% | 5 to 40  | 0 to 50 | 0 to 40 | 0 to 20 | 0 to 40 |
| difference to 100% | 20 to 30 | 0 to 50 | 0 to 40 | 0 to 20 | 0 to 40 |
| difference to 100% | 5 to 40  | 0 to 30 | 0 to 30 | 0 to 20 | 0 to 30 |
| difference to 100% | 10 to 30 | 0 to 30 | 0 to 30 | 0 to 20 | 0 to 30 |
| difference to 100% | 20 to 30 | 0 to 30 | 0 to 30 | 0 to 20 | 0 to 30 |
| difference to 100% | 10 to 30 | 0 to 20 | 0 to 20 | 0 to 20 | 0 to 20 |
| difference to 100% | 10 to 30 | 5 to 15 | 0 to 15 | 0 to 15 | 0 to 15 |
| difference to 100% | 20 to 30 | 0 to 20 | 0 to 20 | 0 to 20 | 0 to 20 |
| difference to 100% | 20 to 30 | 5 to 15 | 0 to 15 | 0 to 15 | 0 to 15 |

The compositions of the invention are  
 5 manufactured by melt-blending the various constituents  
 (twin-screw, BUSS® or single-screw extruders) according  
 to the usual techniques of thermoplastics. The  
 compositions may be granulated for the purpose of a  
 subsequent use (it suffices to remelt them) or they may  
 10 be injected directly into an extrusion or co-extrusion  
 mould or device to manufacture tubes, plates, films or  
 profiles. A person skilled in the art may readily  
 adjust the compounding temperature to obtain a  
 transparent material; as a general rule, it suffices to  
 15 increase the compounding temperature, for example to  
 about 280 or 290°C.

The compositions of the invention may comprise  
 stabilizers, antioxidants or UV stabilizers.

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### EXAMPLES

The following products were used:

ASAP: amorphous semi-aromatic polyamide  
PA-12/BMACM, TA/BMACM, IA synthesized by meltpoly-  
5 condensation using bis(3-methyl-4-amino-  
cyclohexyl)methane (BMACM), lauryllactam (L12) and  
isophthalic and terephthalic acid (IA and TA) in a  
1/1/0.3/0.7 molar ratio.

PA-11: polyamide 11 with an  $\overline{M}_w$  of 45 000 to  
10 55 000.

PA-11 cata: a polyamide 11 with an  $\overline{M}_w$  of 45 000  
to 55 000 and containing 3 700 ppm of isophosphoric  
acid catalyst.

PEBA: a copolymer containing PA-12 blocks with  
15 an  $\overline{M}_n$  of 5 000 and PTMG blocks with an  $\overline{M}_n$  of 650 and  
an MFI of 4 to 10 (g/10 min at 235°C under 1 kg).

L3210: Lotader®3210, an ethylene/butyl  
acrylate/maleic anhydride copolymer in weight  
proportions of 90/7/3, with an MFI at 190°C under  
20 2.16 kg of between 4 and 6, which is a random copolymer  
obtained by high-pressure radical-mediated catalysis.

PA-12: a polyamide 12 with an  $\overline{M}_w$  of 45 000 to  
55 000.

AX8840: Lotader®AX8840, an ethylene-glycidyl  
25 methacrylate copolymer in weight proportions of 92/8  
with an MFI at 190°C under 2.16 kg of between 4 and 6.

Lyl: Lotryl®7BA01, an ethylene/butyl acrylate  
copolymer with weight proportions of 93/7 and an MFI at  
190°C under 2.16 kg of between 0.5 and 2.

L/Lyl: a blend of AX8840 and of Lyl in  
30 proportions of 25/75 by weight.

The results are given in Table 2 below. The  
amorphous polyamide (B) is IPDA,12, the product of  
condensation of isophoronediamine and of Cl2 acid. The  
crystallinity is expressed by the heat of fusion  
35 divided by a constant. The modulus of flexure is  
measured on a sample conditioned for 15 days at 23°C  
and 50% RH (relative humidity). The visual sensation  
and the feel sensation are determined on the

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composition extruded in the form of a sheet. In the "examples" column, the number followed by "c" means that this is a comparative example.

The preceding example can be repeated with similar success by substituting the generically or specifically described reactants and/or operating conditions of this invention for those used in the preceding example. Also, the preceding specific embodiments are to be construed as merely illustrative, and not limitative of the remainder of the disclosure in any way whatsoever.

The entire disclosure of all applications, patents and publications, and of corresponding French application 0101114, are hereby incorporated by reference.

From the foregoing description, one skilled in the art can easily ascertain the essential characteristics of this invention and, without departing from the spirit and scope thereof, can make various changes and modifications of the invention to adapt it to various usages and conditions.

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Table 2

| Examples | (A) Semi-crystalline PA difference to 100% | (B) amorphous PA containing cycloaliphatic units | (C) Supple polyamide | (D) Compatibilizer | (M) Supple modifiers | Light transmission (560 nm, thickness 2 mm) | Compounding temperature | m.p. |
|----------|--|--|----------------------|--------------------|----------------------|---|-------------------------|------|
| 1c       |  |  | PA11 + 25% PASA      |                    |                      | > 80%                                       | 320                     | 185  |
| 2c       | PA11                                       |  |                      |                    |                      | < 50%                                       |                         | 189  |
| 3        | PA11                                       | 10%  |                      |                    |                      | > 60%                                       | ≤ 270                   | 189  |
| 4        | PA11                                       | 25%  |                      |                    |                      | > 80%                                       | ≤ 270                   | 189  |
| 5        | PA11                                       | 40%  |                      |                    |                      | > 80%                                       | ≤ 270                   | 185  |
| 6        | PA11                                       | 25%  | 10% PEDA             |                    |                      | > 80%                                       | ≤ 270                   | 189  |
| 7        | PA11                                       | 25%  |                      |                    | 6% I3210             | > 80%                                       | ≤ 270                   | 189  |
| 8        | PA11                                       | 25%  |                      |                    | 6% AX8840            | > 80%                                       | ≤ 270                   | 189  |
| 9        | PA11                                       | 25%  | 10% PEDA             |                    | 6% I3210             | > 80%                                       | ≤ 270                   | 189  |
| 10       | PA11                                       | 25%  | 10% PEDA             |                    | 36% I/Lyl            | > 60%                                       | ≤ 270                   | 189  |
| 11c      | PA12                                       |  |                      |                    |                      | < 50%                                       |                         | 178  |
| 12c      | PA12                                       | 25%  |                      |                    |                      | > 80%                                       | 350                     |      |
| 13c      | PA12                                       | 25%  |                      |                    |                      | < 30%                                       | 270                     |      |
| 14       | PA12                                       | 10%  |                      | 12% PALICATA       |                      | > 60%                                       | ≤ 270                   | 178  |
| 15       | PA12                                       | 25%  |                      | 12% PALICATA       |                      | > 80%                                       | ≤ 270                   | 178  |
| 16       | PA12                                       | 25%  |                      | 12% PALI           |                      | > 80%                                       | ≤ 300                   |      |
| 17       | PA12                                       | 25%  | 10% PEDA             | 12% PALICATA       |                      | > 80%                                       | ≤ 270                   |      |
| 18       | PA12                                       | 25%  |                      | 12% PALICATA       | 6% I3210             | > 80%                                       | ≤ 270                   |      |
| 19       | PA12                                       | 25%  | 10% PEDA             | 12% PALICATA       | 6% I3210             | > 80%                                       | ≤ 270                   |      |
| 20       | PA12                                       | 25%  | 10% PEDA             | 12% PALICATA       | 36% I/Lyl            | > 60%                                       | ≤ 270                   |      |

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